

## ABSTRACT OF THE DISCLOSURE

A planned production volume in each of production lines, the work force required for production of the planned production volume in the production lines, a tact time, an overtime, a holiday service duty, a work force and so on are initially set based on a required production volume of an article i. The work force, the summated work forces and the planned production volume are successively changed at a predetermined interval to calculate an evaluating value as a cost required for production of the article i of the planned production volume. A set value corresponding to a minimum evaluating value is outputted as an article supply plan value. These processings make it possible to quickly draft a production plan for producing the article at low costs.

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